

Work Order ID 63839

November 16, 2010 9:26:18 AM

Page 1

Item ID: D212-725-1-089

Accept

Setup Start

Revision ID:

Stop

Item Name: Strap

Start Date: 11/16/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

F

0.00

0.00

0.00

0.00

100



Waterjet

FLOW CNC Waterjet

Spav

Memo

1-Cut as per Dwg

Dwg Rev.

Prog Rev.

2-Deburr if necessary

110



QC

Quality Control

QC Inspect parts off machine FAI/FAIB

Memo

(3X)

= 7 m, 1 10/12/17

8 10/12/17

(x3)

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Page 2

Item ID: D212-725-1-089

Accept



Setup Start



Revision ID:

Stop



Item Name: Strap

Start Date: 11/16/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

WIA

130

Identify as per dwg & Stock Location: 389

0.00



Packaging

Memo

0.00

Packaging

10/18/17

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/17
MK
10-12-19

Picklist Print

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Work Order ID: 63839

Parent Item: D212-725-1-089

Parent Item Name: Strap




Start Date: 11/16/10

Required Date: 11/17/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M301S0.050		Purchased	No				sf	0.0000	0.3	0.6			
													
301 SS sheet .050 - 1/4 hard													

~~11/17/10~~
11663 u



m. d. w/12/17

0.050

51.75

0.80

R0.25 TYP

D212-725-1-089 STRAP

M30150.050

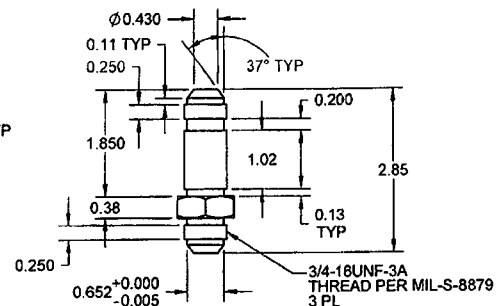
R0.06
TYP

27.75

2.11

D212-725-1-091F FLAT PATTERN0.030
R0.13
1.10
1.10**D212-725-1-091 ANGLE**

(MAKE FROM D212-725-1-091F FLAT PATTERN)

**D212-725-1-093 UNION**

SCALE 2X

**D212-725-1-089 NOTES:**

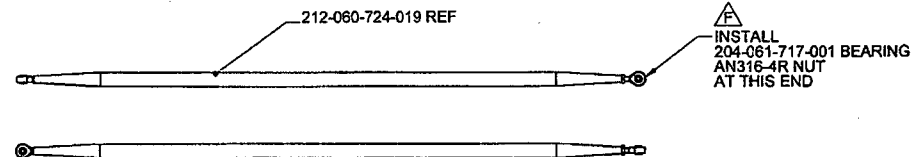
1) MATERIAL: AISI 301 STAINLESS STEEL 1/4 OR 1/2 HARD 0.050 (18 GAUGE) SHEET, PER AMS-5517/-5518

**D212-725-1-091 NOTES:**

2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER AMS-5513/-5524 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

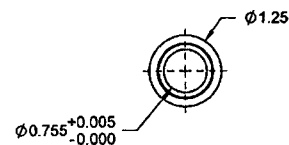
**D212-725-1-919 ROD ASSEMBLY**

(MADE FROM 212-060-724-019)

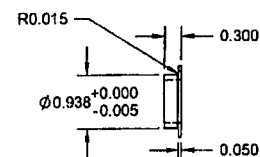
D212-725-1-919 NOTES:

- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

w/o 63839

**D212-725-1-105 BUSHING**

SCALE 2X

**D212-725-1-105 BUSHING:**

1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)




D212-725-1-093 UNION:

2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED
09/04/02

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 33 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Colin Gould [cgould@eaglecopters.com]
Sent: November 15, 2010 11:57 AM
To: 'L Lacelle'
Subject: RE: D212-725-1

It should go out today.
Colin

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, November 15, 2010 8:49 AM
To: 'Colin Gould'
Cc: 'Robert Fuentes'
Subject: RE: D212-725-1

Hi,
Are you sending this out to me?

Thx
Linda

From: Colin Gould [mailto:cgould@eaglecopters.com]
Sent: November 11, 2010 1:42 PM
To: 'Robert Fuentes'; 'L Lacelle'
Subject: RE: D212-725-1

Good day

This is a structural part so we can't change material. I have a partial sheet of 301 1/4 hard 0.050 I could send to you. It would be easier than the paperwork it would require for us to manufacture it for you to sell back to us.

Would you want it in a 10.5" x 69.5" piece or several strips 0.800" wide?

Colin

From: Robert Fuentes [mailto:rfuentes@dartaero.com]
Sent: Thursday, November 11, 2010 10:41 AM
To: Colin Gould
Subject: FW: D212-725-1

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, November 10, 2010 8:10 AM
To: 'Robert Fuentes'
Subject: FW: D212-725-1

Hi Roberto,
All the mat'l is now in, so I'm hoping to ship everything else this week.
Can we use 303 or 304 sheet for the D212-725-1-089 ?
Please let me know asap.

Thx
Linda

11/15/10